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In one particular exemplary embodiment of the invention, a firm bookcase is provided, which comprises a spine edge and is joined to the book block in the region of the spine edge. A gauze, which is glued to the folded edge region of the folded sheets and to the spine edge of 5 the bookcase, is provided, to advantage.

By virtue of the fact that the individual quarter sheets are glued in the folded edge region, there results a working surface for the glue, which working surface is enlarged by about 1.5 times as compared to the 10 milled binding margin in conventional glue binding. This also ensures an appropriately higher durability of the binding. When using folded sheets of coated paper, the folded edge region is fractured or machined otherwise so that the glue can completely penetrate the fibrous structure of the folded sheet. Additional advantages and design forms 15 of the invention will be explained with reference to the following description of an exemplary embodiment and the drawings, in which:

Fig. 1 is a cross-section of a book of the invention, and

20 Fig. 2 is an enlarged cross-section in the region of the spine of the book.

The book shown in the drawings substantially comprises a book case 1 and a book block 2, the book case being formed of a firm upper book

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cover 1a [sic; 1.1] and a firm lower book cover 1b [sic; 1.2].

Details regarding the type of binding will be described below with reference to Fig. 2:

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The book block 2 comprises a plurality of four-sided folded sheets 2a, which are disposed next to each other and are glued together in the folded edge region 2b. Said folded sheets are glued together with the help of a gauze 3 and suitable glue 4.

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In this type of binding, it is important to ensure that the folded edge region 2b of the folded sheets 2a allows the glue to penetrate the fibrous region of the folded sheets. When using coated paper, in which a chalk layer 5 is applied on the surface as seen in Fig. 2, the folded edge region 2b of the folded sheets must be machined in a manner, which ensures that the glue 4 used for gluing the folded sheets together can penetrate the folded sheets in the folded edge region. For this type of machining, for example, the paper coating in the folded edge region is fractured deliberately in the folding process. This measure ensures the sufficient penetration of the glue in the folded edge region in the case of coated paper as well. The penetration of the glue is indicated using arrows in the drawings.

25 The curved folded edge region 2b of the four-sided folded sheets disposed next to each other results in a working surface for the glue 4, which working surface is enlarged by about 1.5 times as compared to conventional glue binding, in which a milling process is performed in the region of the binding margin.

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Tests underlying the invention have shown that this results in a binding that is 50% more durable than conventional glue binding.

In the binding of the invention, a firm bookcase is used expediently,
5 which is provided with the reference numeral 1.2 in Fig. 2 and comprises a spine edge 1.2.a. The bookcase is glued in the region of its spine edge 1.2.a to the book block.

As is obvious from Fig. 1, in particular, the upper and lower book
10 covers 1.1 and 1.2 are completely separate from each other. The bookcase is joined to the book block 2 in the region of the spine by means of gauze and glue application, as shown in Fig. 2.

Furthermore, the book comprises a book jacket 8, which is permanently
15 glued to the book case in the region of the upper and lower book covers, barring a 3 mm broad margin proceeding parallel to the spine at the front and the back and the spine itself.

One advantage of a book jacket, which is permanently joined to the book
20 case, is that it will not be able to slip when the book is being used and another advantage is that the embossing and labeling processes of the book case can be dispensed with altogether. Moreover, the book jacket 8 can be labeled and/or embossed in a significantly economical way due to its appropriately thinner material.

25 The front and back endpapers 6, 7 are glued, as usual, to the inner side of the book case, while the book jacket 8 is glued at least on the

outer side of the bookcase. In the exemplary embodiment illustrated, the book jacket 8 is pulled around the front edge of the book cover and its inner side, which it covers approximately halfway through.

- 5 The bookcase can be formed with relative ease in this exemplary embodiment by a cardboard of a thickness ranging from 0.8 to 2.0 mm or more by way of example. Since this firm bookcase is laminated using the front and back endpapers as well as the book jacket, it is possible to dispense with expensive labeling and/or embossing processes of the
- 10 bookcase.

The front and back endpapers 6, 7 can be glued to the bookcase (book covers 1.1 and 1.2 respectively) in such a way that the front and back endpapers have a smooth surface. In conventional binding, there results a typically unsightly bulge in the border areas of front and back endpapers. This bulge is formed as a result of the lamination of the conventional book cover and the gluing of the gauze on the inner side of the book cover.

- 20 The book, when open, displays an excellent ability to lay flat, thereby also preventing the formation of shadows in the gutter region, in particular. Furthermore, this makes it possible to print, inside every four-sided folded sheet, a print image that bleeds across the gutter and the quality of which is not affected adversely by improper register
- 25 in the gutter region. Since no stitch binding is provided, no needle holes result, which the glue could penetrate and thereby adversely affect the image.

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Although the individual sheets are not secured using an additional stitch-binding process, the resulting binding has extraordinarily reliable durability, which exceeds that of conventional glue binding by about 50%.

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Another advantage is that the book spine is displaceable, which makes it possible for the book to lay flat at an angle of 180° when open. This, in turn, enables the book to be opened easily and its pages to be turned over without any obstruction.

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